

Work Order ID 55890

February 4, 2010 7:38:46 AM

Page 1

Item ID: D2989-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Basket Lid Assembly

Start Date: 2/05/10 Start Qty: 1.00

Cust Item ID:

Required Date: 2/12/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2989

Rev D

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs in DT9446 jig, weld as per dwg D2989
2- tack weld mesh on basket as per dwg D2989 using DT9446 jig
3- to locate hinges and shims use D2989-041, weld as per dwg D2989
A/R ER316 S.S. Rod Batch: 4113328

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

SL 10/02/14 (1x)

Pl 10.02.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55890

February 4, 2010 7:38:47 AM

Page 2

Item ID: D2989-043

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Setup Start

Revision ID:

Stop

Item Name: Basket Lid Assembly

Start Date: 2/05/10 Start Qty: 1.00

Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8.10.02/17

(X)

BK 10-02-18
=> 10/02/18

(X1)

M113170

8:30 AM

400°F

9:00 AM

9:00 AM

400°F

9:30 AM

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D2989-043

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Setup Start



Revision ID:

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Item Name: Basket Lid Assembly

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Required Date: 2/12/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

ES 10/02/19 @

150

Identify as per dwg & Stock Location: *GA*

0.00



Packaging

Memo

0.00

Packaging

ES 10/02/19 @

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/23

*ME
10-2-22*

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

February 4, 2010 7:38:43 AM

Page 1

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Work Order ID: 55890



Parent Item: D2989-043



Parent Item Name: Basket Lid Assembly

Start Date: 2/05/10

Required Date: 2/12/10

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D2221-1 Manufactured No 100 Each 10.0000 1.0000



Rib



SAD 10-02-12

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 1

48101 1

Main Warehouse

WA 9

53662 9

D2989-3 Manufactured No 100 Each 4.0000 1.0000



Rib



SAD 10-02-12

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 4

53551 2

54276 2

D2989-4 Manufactured No 100 Each 4.0000 1.0000



Rib



SAD 10-02-12

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 4

53552 2

54277 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 55890



Parent Item: D2989-043



Parent Item Name: Basket Lid Assembly

Start Date: 2/05/10

Required Date: 2/12/10

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D2989-5 Manufactured No 100 Each 6.0000 2.0000
 Rib

SAD 10-02-12

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6	
53553	2	
54226	4	

2

D3182-1 Manufactured No 100 Each 12.0000 2.0000
 Hinge

SAD 10-02-12

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	12	
53445	12	

2

D3442-3 Manufactured No 100 Each 8.0000 2.0000
 Shim

SAD 10-02-12

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	8	
42718	1	
53137	7	

2

February 4, 2010 7:38:44 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 4, 2010 7:38:44 AM

Page 3

Work Order ID: 55890



Parent Item: D2989-043



Parent Item Name: Basket Lid Assembly

Start Date: 2/05/10

Required Date: 2/12/10

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D3827-041 Manufactured No 100 Each 10.0000 1.0000
 SAD 10-02-12
 Rib Assembly (Inboard)

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	10	
53901	4	
54866	6	

D3832-5 Manufactured No 100 Each 4.0000 1.0000
 SAD 10-02-12
 Mesh (Lid)

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	4	
52049	1	
53220	3	

D3833-5 Manufactured No 100 Each 25.0000 2.0000
 SAD 10-02-12
 Mesh (Lid End)

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	25	
51305	4	
53722	21	

February 4, 2010 7:38:44 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 55890



Parent Item: D2989-043



Parent Item Name: Basket Lid Assembly

Start Date: 2/05/10

Required Date: 2/12/10

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D3838-041 Manufactured No 100 Each 4.0000 1.0000



Rib Assembly (Basket Lid, LH)

SAM 10-02-12

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 4

53550 2

54274 2

1

D3838-042 Manufactured No 100 Each 4.0000 1.0000



Rib Assembly (Basket Lid, RH)

SAD 10-02-12

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 4

53549 2

54275 2

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-11/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG), D2989-9/-10 (NOW ON D3836 DWG), D2989-11/-12 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.	AS	D2989	SHEET 1 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BASKET LID ASSEMBLY	NTS
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08/11/16

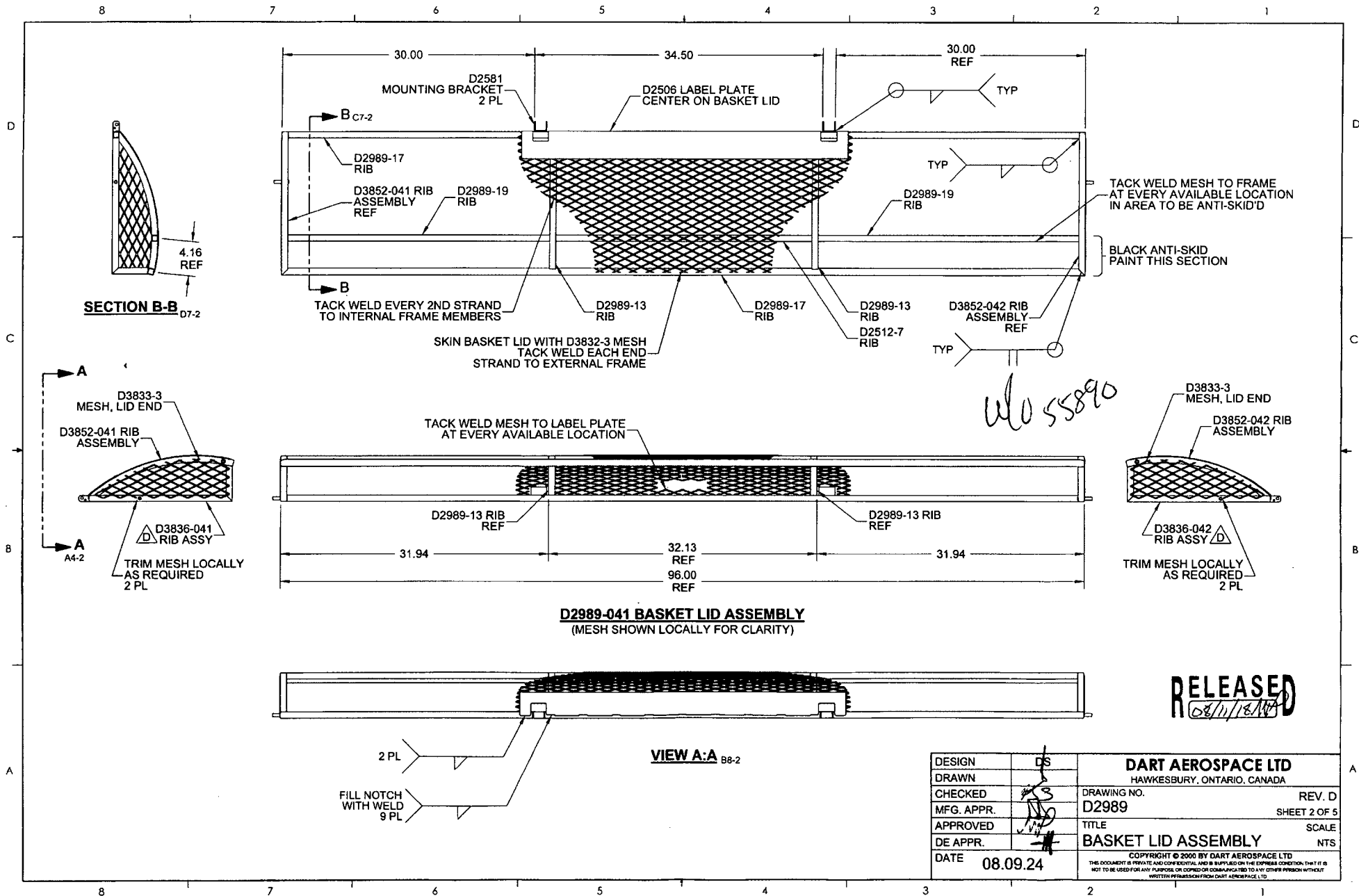
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DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D2989	SHEET 2 OF 5
APPROVED		TITLE	SCALE
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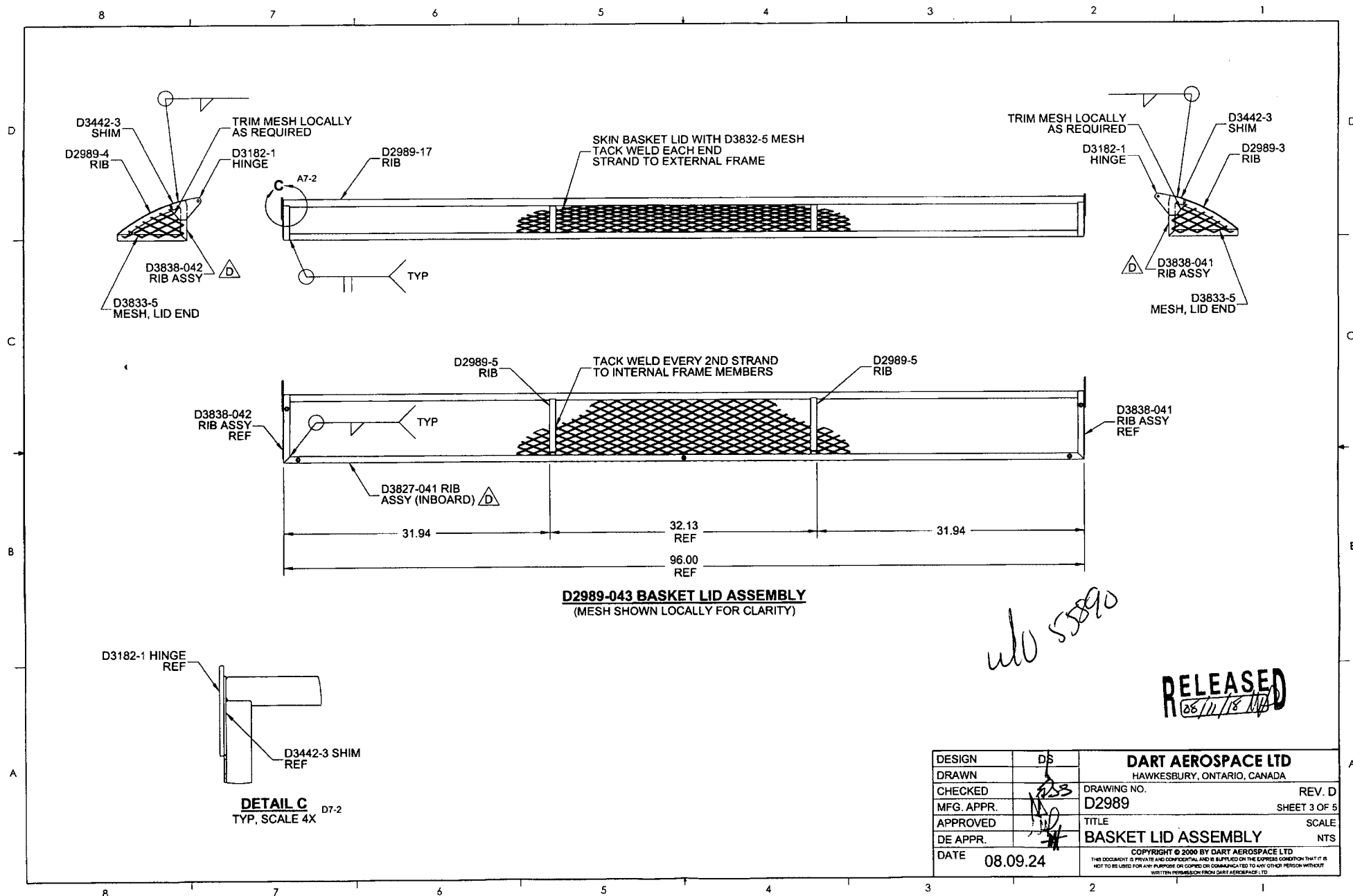
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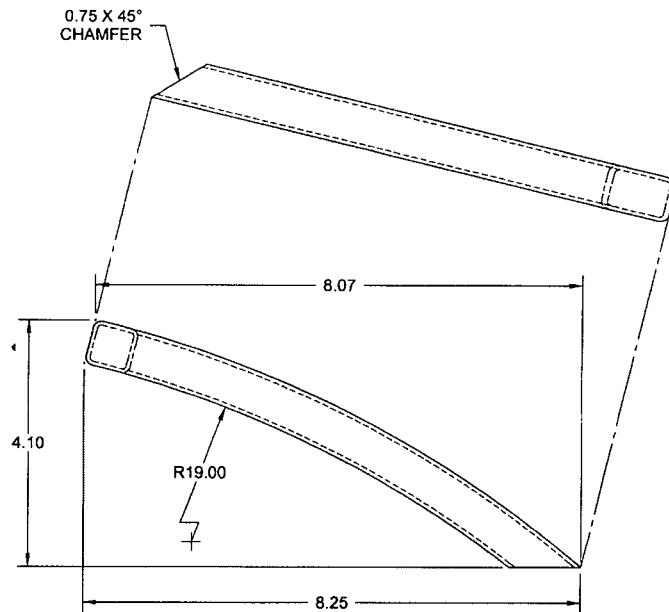
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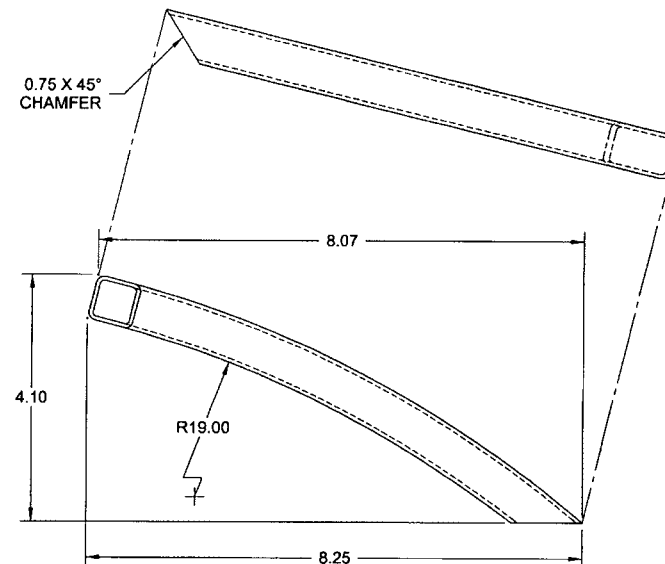
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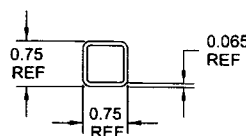
D2989-3 RIB



D2989-4 RIB

ulu 55890

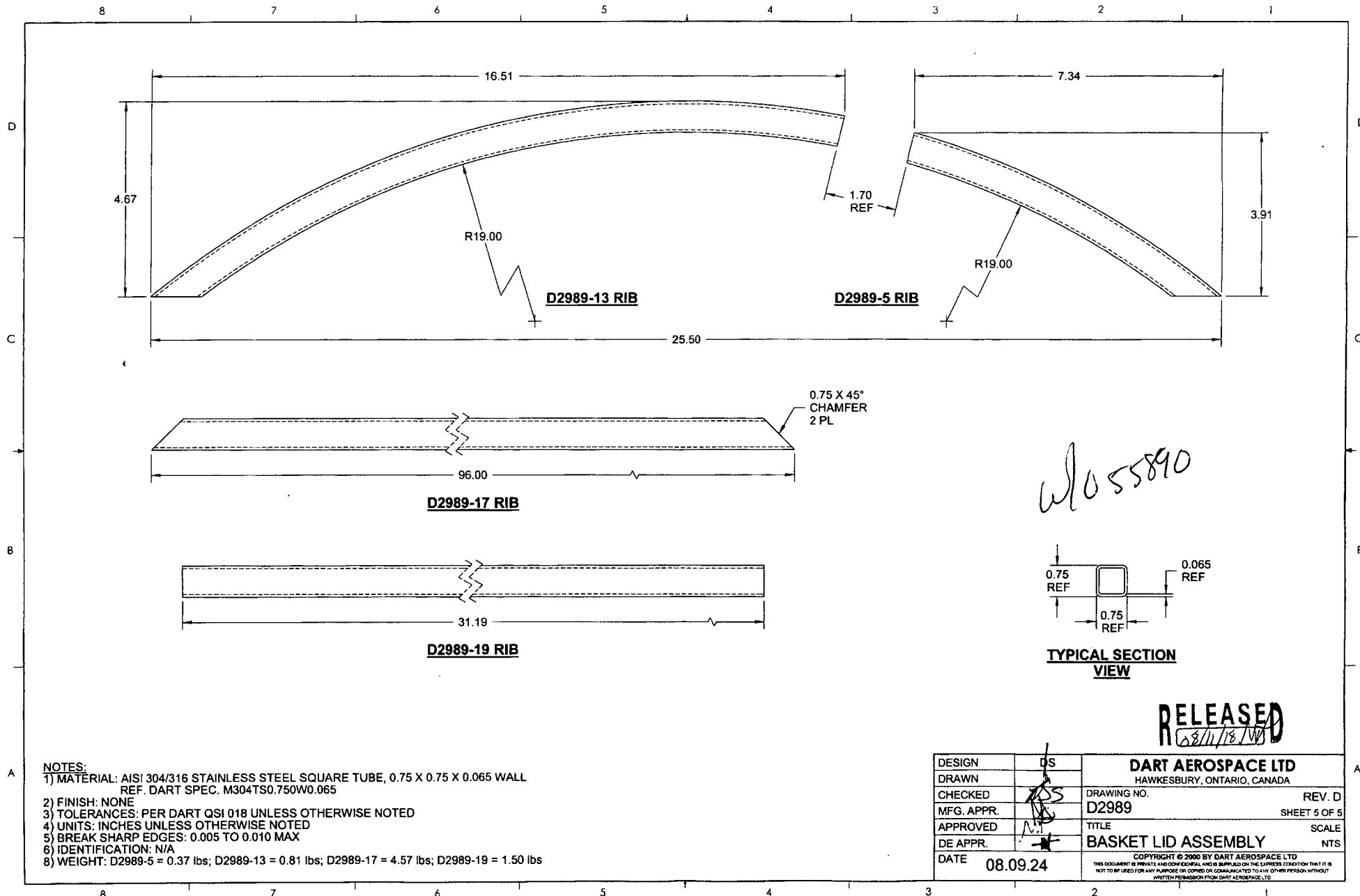
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08/11/18



**TYPICAL SECTION
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2989	REV. D
MFG. APPR.			SHEET 4 OF 5
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DE APPR.	DS	BASKET LID ASSEMBLY	NTS
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